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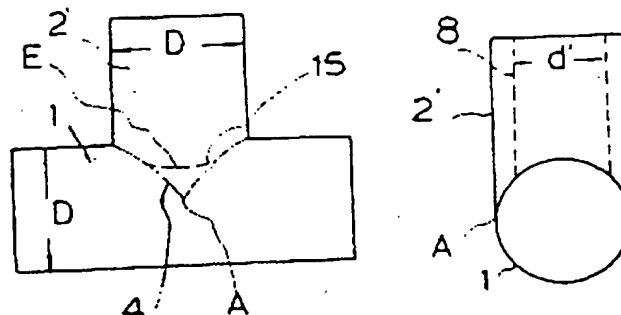
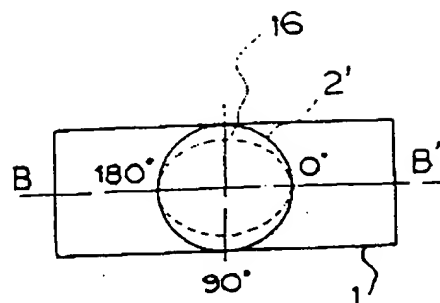
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TITLE : SADDLE SHAPED AUTOMATIC WELDING METHOD



ABSTRACT : PURPOSE: To reduce a welding defect, and to raise the work efficiency, by moving a torch along an intersection line of a base pipe and an oval column face inscribed to a branch pipe, when butt-welding the base pipe and the branch pipe in the shape of T.

CONSTITUTION: When the end face of a branch pipe 2' of an outside diameter (d) is butted in the shape of T with the side face of a base pipe 1 of an outside diameter D and they are welded automatically, an oval pipe whose long axis is made equal to an inside diameter d' of the branch pipe 2' and whose short axis is made  $(d-2\Delta d)$  is supposed. An intersection line 15 formed by penetrating this oval pipe and the base pipe 1 is made a groove center line. Subsequently, the end part of the branch pipe 2' is cut along said intersection line 15, also the opening of the base pipe 1 is formed to a saddle shape, and a welding torch is moved along the intersection line 15. According to this method, a plane projection of the intersection line 15 is overlapped with an oval column face 16, and its elevated face projection becomes a smooth saddle shape E having no break point. Accordingly, a welding defect is reduced, and the work efficiency is raised.

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